



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RB2300COMB
Job Sheet 196819



Part No: RB2300COMB

Job Qty: 1 pcs

Part Name: Power Turbine Support Cleaning C-20, C-30, C-40 & C47



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/21/19

Job Tracking No:

Due Date: 7/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description: ORDER 17421

Note: DWG RB2300COMB Rev.B IPP Rev. A 19.01.21 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	7/5/19		0.00	0.07	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	1 pcs	7/5/19		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
130	Packaging 3-1 - Stock - B4B	1 pcs	7/5/19		0.00	0.00	Packaging 3 - 1 - B4B		JUN 26 2019 DAS 40 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		



Container No: S193885



Part: RB2300COMB

Job No: 196819

Serial No/Batch: S193885

Revision: B

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/26/19

Plex 6/21/19 10:40 AM Dart.lajeunesse.marie

				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	1 pcs	7/5/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - FG - 53

JUN 28 2019
DAS 70

Part Op 100 - 1- Assemble/Pick as per DWG RB23007615 2- ***NOTE Red Barn sticker on sheet #8 N/A as per Eng. 9-89
 Descriptions: 110 - (QC5- Inspect part completeness to step on W/O)
 130 - (Identify as per dwg & Stock Location: _____) Identify and Stock
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
K206	Flambeau Plastic Box (Clean Out)	1 Ea (1 ea)	100-Small Fab - 1	5127655
PAD210	Foam Ø1 X 1 replace item 1887T48	.2220 sf (.222 ea)	100-Small Fab - 1	5021250
RB23003267-1	Clean Guide	1 pcs (1 ea)	100-Small Fab - 1	5165940
RB23007615-11	#12 Drill Bit	1 pcs (1 ea)	100-Small Fab - 1	5119734
RB23007615-13	Saw	1 pcs (1 ea)	100-Small Fab - 1	5141755
RB23007615-15	Wire	4 ft (4 ea)	100-Small Fab - 1	5097885
RB23007615-21	Guide	1 pcs (1 ea)	100-Small Fab - 1	5141679
RB23007615-23	Socket Head Cap Screw	3 pcs (3 ea)	100-Small Fab - 1	5144310
RB23007615-25	Strut Checking Gauge	1 pcs (1 ea)	100-Small Fab - 1	5141735
RB23007615-3	#56 Drill Bit	1 pcs (1 ea)	100-Small Fab - 1	5144369
RB23007615-5	#52 Drill Bit	1 pcs (1 ea)	100-Small Fab - 1	5144370
RB23007615-7	#27 Drill Bit	1 pcs (1 ea)	100-Small Fab - 1	5144371
RB23007615-9	#22 Drill Bit	1 pcs (1 ea)	100-Small Fab - 1	5119743

152B
 1391
 140

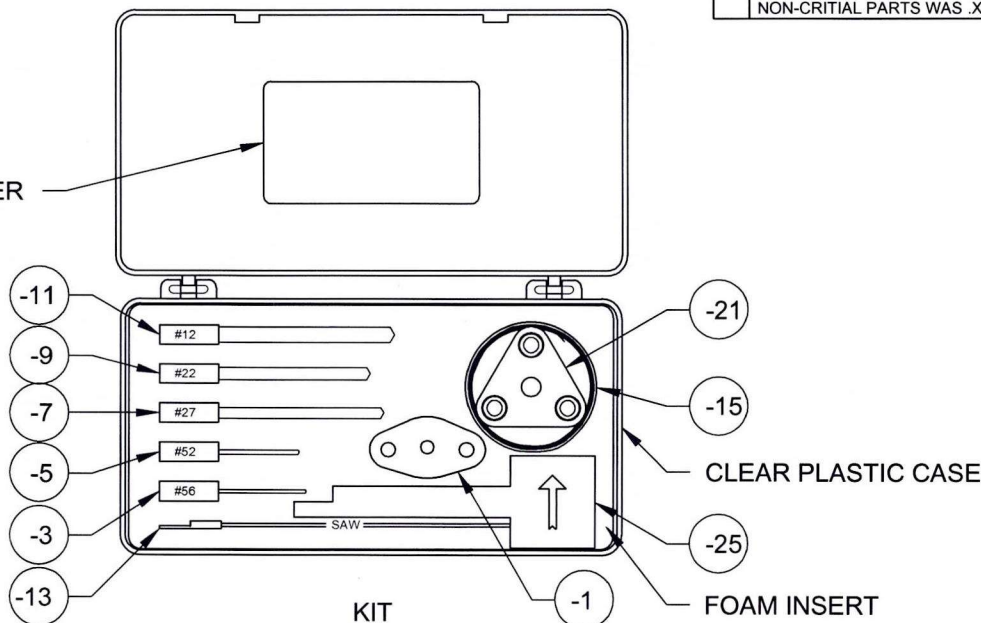
Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	K206	1	33	0
	PAD210	0	10	0
	RB23003267-1	1	2	0
	RB23007615-11	1	14	0
	RB23007615-13	1	17	0
	RB23007615-15	4	136	0
	RB23007615-21	1	11	0
	RB23007615-23	3	45	0
	RB23007615-25	1	14	0
	RB23007615-3	1	13	0
	RB23007615-5	1	13	0
	RB23007615-7	1	1	0
	RB23007615-9	1	5	0
Part Specifications				
Specifications could not be found.				

Plex 6/21/19 10:40 AM Dart.lajeunesse.marie

This drawing, specifications, and concepts contained herein are the sole property of Red Barn Machine, and may not be reproduced or used in any fashion without the prior written permission of Red Barn Machine.

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
A	CH'D TITLE;OCK & REVISION BLOCK, ADDED DWG'S FOR CASE, FOAM INSERT, & ASSY.	8/11/09	RJC	RW
B	-1 CH'D DIMS WAS R.750 IS R.75, WAS R1.000 IS R1.00, WAS .040 IS 2X .040. -2 ADDED NOTES TO SHEET. -3, -5, -7, -9, -11, -13, -21, -23 MOVED TO SEPARATE SHEETS & ADDED B/O INFO TO BOM. -21 CH'D DIM TOLERANCE WAS R.300 IS R.30. ADDED NOTE 3X 1/4-28 THRU EQUALLY SPACED. ADDED MISSING DIM .644. -25 ADDED WATERJET FOLDER & DXF TO TOOL FILE. CH'D TOLERANCE ON ALL NON-CRITICAL PARTS WAS .XXX IS .XX.	2/3/14	DPD	RJC

RED BARD STICKER



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 196819 M15
1906-21

ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-1	1	GUIDE	6061	Ø2 x 1-1/16 (Ø2 FOR EASE OF MANUFACTURE)	2
			-2	5	BLOCK	6061	5/16 HEX x 1	3
			-3	1	#56 DRILL BIT		SEE -2 -56 FOR BLOCK METHODS	3
			-5	1	#52 DRILL BIT		SEE -2 -52 FOR BLOCK METHODS	3
			-7	1	#27 DRILL BIT		SEE -2 -27 FOR BLOCK METHODS	3
			-9	1	#22 DRILL BIT		SEE -2 -22 FOR BLOCK METHODS	3
			-11	1	#12 DRILL BIT		SEE -2 -12 FOR BLOCK METHODS	3
			-13	1	SAW		6" LENGTH #HAC5012BX (BESTWAY PRODUCTS)	4
							.050 ROUND x 6 SECTION	
		B/O	-15	4'	WIRE		.041 WRAPPED AROUND 1-7/8 ARBOR	1
			-21	1	GUIDE	6061	Ø2 x 1-1/16	5
			-23	3	SOCKET HEAD CAP SCREWS	STEEL	1/4-28 UNF x 3/8 MODIFIED MCMaster-CARR #91251A435	6
			-25	1	STRUT CHECKING GAGE	6061	.05 x 1-1/2 x 4-7/8	7
		B/O		1	CLEAR PLASTIC CASE		FLAMBEAU #K206 OR EQUIV.	8
		B/O		1	CRAFT FOAM		1 x 4 x 8	8
		B/O		1	RED BARN STICKER		STICKER FACE INSIDE LID FACING OUT	8
ASSY #								

NOTES:

1. RB2300COMB IS A COMBINATION OF RB23007615 & RB23003267.



RED BARN MACHINE

TITLE

POWER TURBINE CLEANING KIT

DWG NO.

RB2300COMB

REV

B

UNLESS OTHERWISE SPECIFIED
DIMENSIONS ARE IN INCHES

TOLERANCES ON:

DECIMALS

XXX ± .005

XX ± .01

X ± .1

FRACTIONS ± 1/32

ANGLES ± 5°

UNLESS OTHERWISE SPECIFIED
1. BREAK ALL SHARP EDGES
.015 x 45° PR .015 R
2. DIMENSIONAL LIMITS APPLY AFTER PLATING

DRAWN BY:

CLOUGH

APPROVED

D. West

HEAT

TREAT

FINISH

SPEC

USED ON MODEL

ALLISON C20 & C30

SCALE

1:3

DATE

2-1-01

SHEET

1 of 8

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					